

17

DART AEROSPACE LTD	Work Order:	20706
Description: Hinge	Part Number:	D3182-1
Dwg: D3182 Rev. A	Qty:	50 54
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	04.04.13	50
2	PG	Issue P/O: 20010352 Email or ship DXF file to vendor Laser Cut D3182-1 per Dwg D3182 Material release note required	u	04.04.13	50
3	RG	Receive and inspect for transit damage Ensure the material release note is attached	AP	04/04/30	54
4	QC6	Inspect dimensions per template D3182-1T1	AP	04.05.03	54
5	GA	Deburr if necessary	SB	04/05/04	54
6	WS	Identify and Stock	SB	04/05/04	54
7	AC	Cost / part 4.35	54C	04-05-05	54
8	DC	Close W/O 4.35 Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	03.01.29	New issue	KJ/RF	RF

RELEASED
03.01.31 RF

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

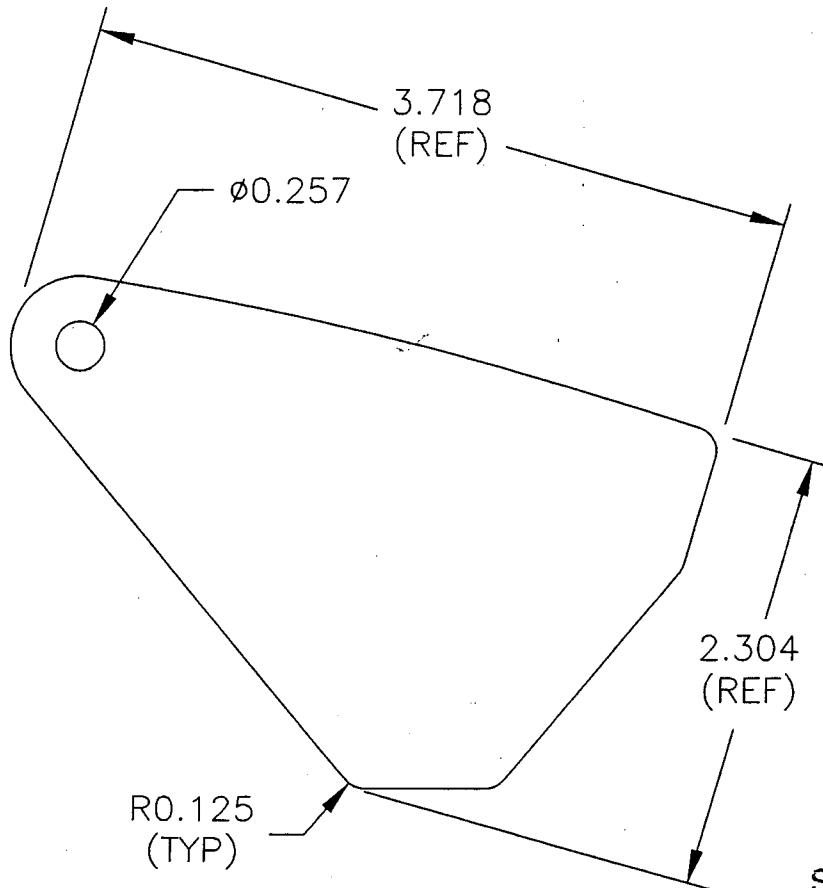
NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncb.doc

QA: N/C Closed: _____ Date: _____



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3182	REV. A SHEET 1 OF 1
DATE 03.01.21		TITLE HINGE	SCALE 1:1
A	03.01.21	NEW ISSUE	

RELEASED
03.01.21 *[Signature]*



D3182-1 HINGE

- 1) MACHINE D3182-1 PER DART DWG "D3182-1.DWG"
- 2) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK
(REF DART SPEC. M304S11GA)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 20706

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 12, 2004
03:42 pm

Work Order No : 0020706
Project Name : D3182-1
Project For : WK417
Work Order Type : Main
Main WO Number :
House Part Number : D3182-1
Description : Hinge
Manufactured : Yes
Amount Req'd : *500*
Amount Done : 0
Start Date : 04-12-04
Est Finish Date : 04-21-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	-0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

14. MAR. 2002 14:06

ALZ GROTE EXPORT 32 89 301949

-NO. 657- P.7/12

ALZ

Handelsvermittlungsgesellschaft

Markenbezeichnung

Gemeinschaft: Zone SA, Schwanenweg 5, D 3800 Garm

Tel. (053) 30 21 11 - Telefax (053) 26 23 80

Telefax 330534 addres b

H.R. Teegenfeldt 41.051 - B.T.W. 41.051.27.274



Der TÜV Rheinland hat mit Schreiben vom 27. März 1992 auf die Gegenzeichnung verzichtet.

SURVEYOR MARK
CACHET DE L'EXPORT
STEMPEL DES WERKSACHVERSTÄNDIGENCertificate of test - Mill certificate
Certificat de Réception C.C.P.U.No 2002.0037314
NrAbnahmeprüfzeugnis B
nach DIN 60048/2.1.8 - NFA 80001/3.1.8 - EN 10204/3.1.8Approved as supplier according to
ASME - TND 100 standards W E 603
certified and Pressure Equipment
Directive 97/23/EC by TÜVPROC. PROCES: Essais des Matières - VOB - Contrôle des Matières
PROC. FABRIC: Four à Ars - VOB - Contrôle des Matières
FERTIGUNGSSCH: Deutscher-Lichtbogen Garm - VOB - Fertigungssch.

voir ordre n° - voir n° de m/s - Bestell-Nr

0020007207
SP796

sur ordre n° - voir n° de com - Wertgr

47912/329/03

STAINLESS STEEL, COILS, COLD ROLLED, FINISH 2 B

heat n° - n° coïles
Schmelze Nr
K 136018coil n° - n° bobines
Bande Nr
13601820

Specifications - Spécifications - Verschriften

Type - Matériau - Quality

Finish

Conversion test - Contr. Inter - Incertitude Contr.

ASTM A240/A 240M-01
ASME SA 240-01TYPE 304 - S 30400
TYPE 304 - S 304002B
2B

ASTM A262 E - 01 :OK

Dimensions - Abmessungen

mm 3.04 1219.20 0.0

0.0

Material (Code Designation)

Matériau UNS S 30400

Quenching
Hypertemp
Abkühlung

ASTM A240

furnace air

1050°C
at process
Bewerter Luft

Particulars: - Prescriptions - Sonderanforderungen:

AMS 5513-G99 -- ASTM A276/00-A+A312/A312M-01 (CHEM. COMP.) + A666/00
- MATERIAL MERCURY FREE - NO WELD REPAIRING

CHEMICAL ANALYSIS COMPOSITION CHIMIQUE CHEMISCHE ZUSAMMENSETZUNG			MECHANICAL PROPERTIES - PROPRIÉTÉS MEC. - MECH. WERTE				
ELEMENTS	LADE ACIERIE SCHMELZE	PRODUCT PRODUIT STUCKANAL	TENSILE TEST ESSAI DE TRACTION ZUG VERSUCH		ROOM TEMP. - TEMP. AMBI. - RAUMTEMP. OBTAINED - OBTENU - ERGEBNISSE TEST - N° - TEST - PRÜFE		TEMP.
			ASTM A240	KST min. max.	A (T) E	min.	
C	0.042	0.044	Section A-Schnitt		12.46X 2.96		
Mn	1.31	1.32	yield limite 0.2%	30	49.8 49.0		THIS MATERIAL IS SATISFACTORY FOR ASME CODE
P	0.029	0.030	Stressgrenze 1.0%		54.1 52.8		
S	0.004	0.003	penetration resistance	75	98.9 97.6		
Si	0.48	0.48	Zugfestigkeit				
Cr	18.20	18.22	alloy % A50	40	49 50		
Fe	8.14	8.12	alloy % Br. Spec.		50 50		SECTION VIII DIV 1 FERRITATION
Mo			502 / 0.22 %				
Al	0.057	0.056	hardness duroval Hv30	HRB	92 89.0 91.0		
Ni			grain size scale 1000 Korngröße	band prüfung Stagengröße	180° OK	impact strength test essai de chocs Kerbschlagversuch	
TESTS TO VERIFY BATCH AND QUALITY HAVE BEEN CARRIED OUT TESTS DE VERIFICATION DE LA CONFORMITÉ DE LA MARCHÉ FOURNIE VERWECHSELUNGSPRÜFUNG WURDE DURCHFÜHRT							
VISUAL INSPECTION AND DIMENSIONAL CHECK EXAMEN VISUEL ET DIMENSIONNEL DE SURFACE BESICHTIGUNGEN UND ABMESSUNGEN							
GOOD WORKMANSHIP, PERMISSIBLE VARIATIONS IN DIMENSIONS OK							